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RBT18520
Job Sheet 181501



005266

Part No: RBT18520

Job Qty: 1 ea

Part Name: Main Rotor Damper Load Test Device



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/29/18

Job Tracking No:

Due Date: 8/20/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBT18520 REV:11 IPP REV A 18.02.07 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	8/20/18	8/20/18	0.00	0.00	Start Up Small Fab-4		MLL
100	Small Fab	1 pcs	8/20/18	8/20/18	0.08	0.33	Small Fab-9		MLL
110	QC	1 pcs	8/20/18	8/20/18	0.00	0.00	QC5		DAS
130	Packaging	1 pcs	8/20/18	8/20/18	0.00	0.00	Packaging3-2		68
140	QC21-FG	1 Ea	8/20/18	8/20/18	0.00	0.00	QC21		9-89

Part Op 100 - Assemble
Descriptions: 130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
10164	LG. Pistol Case, Plastic	1 Ea (1 ea)	100-Small Fab	5044120
20625A914	Dial Indicator Attchmnt Agd-2 Dial	1 Ea (1 ea)	100-Small Fab	5044125
5416K41	SS Hose Clamp 3.5" Dia.	1 Ea (1 ea)	100-Small Fab	5044121
90108A417	Flat Washer 3/8" Plated	2 Ea (2 ea)	100-Small Fab	5044124
91259A583	Shoulder Screw 5/16" Shoulder Dia, 1" L Shoulder, 1/4"-20 Thread	1 Ea (1 ea)	100-Small Fab	5044123
92845A245	18-8 Ss Extended (Dog) Point Socket Set Screw 10-24 Thread, 1/2" Length	2 Ea (2 ea)	100-Small Fab	5044123
93839A815	Hex Nut 3/8-24 Unf	2 Ea (2 ea)	100-Small Fab	5044123
95615A120	1/4-20 Nylock Nut	1 Ea (1 ea)	100-Small Fab	5044123
AGD-2	1" Dial Indicator 0" to 1" Range	1 Ea (1 ea)	100-Small Fab	5076674
FPSC4-10R	TBD	1 Ea (1 ea)	100-Small Fab	50443521
FPSC5-10R	TBD	1 Ea (1 ea)	100-Small Fab	5044353
RBT18520-1	Lift Device Frame	1 Ea (1 ea)	100-Small Fab	5040963
RBT18520-11A	Weight Assembly	1 Ea (1 ea)	100-Small Fab	5106923
RBT18520-15	Clevis Bracket	1 Ea (1 ea)	100-Small Fab	5049449
RBT18520-16	Indicator Bracket	1 Ea (1 ea)	100-Small Fab	5051546
RBT18520-5	Weldment	1 Ea (1 ea)	100-Small Fab	407020
RBT18520-7	Pivot Bar Weldment	1 Ea (1 ea)	100-Small Fab	5053641
RBT18520-9A	Extension Assembly	2 Ea (2 ea)	100-Small Fab	5104228



Container No: S107007



Part: RBT18520

Job No: 181501

Serial No/Batch: S107007

Revision: 11

Inspector:

Exp Date:

Instructions:

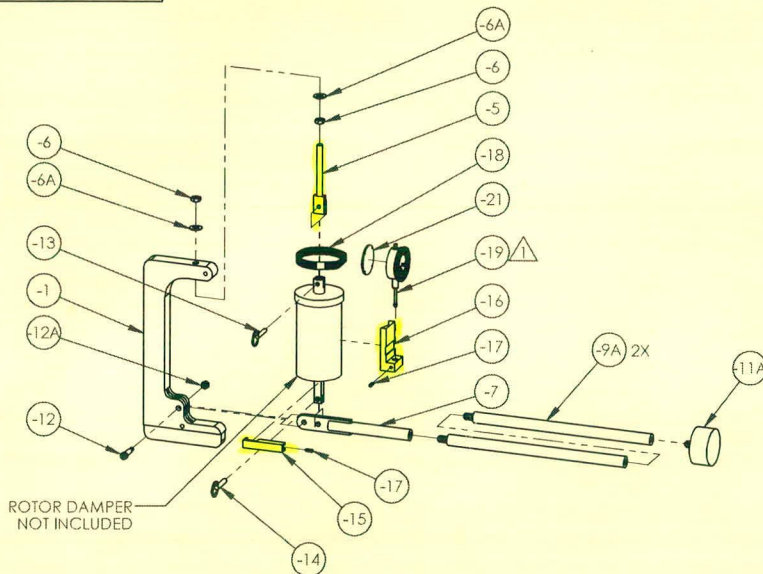
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Date: 08/30/18

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab	10164	1	5	0
	20625A914	1	2	0
	5416K41	1	8	0
	90108A417	2	96	0
	91259A583	1	10	0
	92845A245	2	21	0
	93839A815	2	46	0
	95615A120	1	98	0
	AGD-2	1	3	0
	FPSC4-10R	1	8	0
	FPSC5-10R	1	8	0
	RBT18520-1	1	4	0
	RBT18520-11A	1	0	0
	RBT18520-15	1	4	0
	RBT18520-16	1	4	0
	RBT18520-5	1	0	0
	RBT18520-7	1	4	0
	RBT18520-9A	2	2	0
Part Specifications				
Specifications could not be found.				

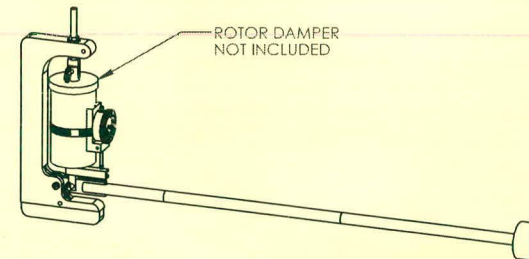
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REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-10 WAS CUT STUDS; -16 TOLERANCE REDUCED TO ENSURE CLEARANCE FOR DIAL INDICATOR.	8/17/2020	-	-
2		CUT -1 FRAME BACK TO .375 NEXT TO Ø5/16 HOLE FOR CLEARANCE	10/30/2021	-	-
3		CHANGED -1 SCREW HOLE FROM REAM TO .3125; -11 ADDED MACHINING TO WEIGHT & SEE TESTING & ENGRAVING; ALSO CREATED A TESTING & WEIGHT CALIBRATION DWG.	8/14/2022	WP	FW
4		COMBINED NINE FILES INTO ONE; INSTALLED NEW TITLE BLOCK, BOM, & REV. TABLE; CREATED CUSTOMER NEW DWG'S; SEPARATED -5 THREADED ROD & -5 TOP BOLT TO -5 TOP BOLT WELDMENT & -5 ALL THREAD; SEPARATED -7 TAB & -7 PIVOT BAR TO -7 PIVOT BAR WELDMENT & -7 PIVOT BAR TAB; CHANGED -12 Ø5/16 X 1 PIN TO -12 SCREW & -12 IN LOCK NUT; CHANGED STAKE OR PIN -10 TO USE LOCITE 609.	11/29/2022	WP	FW
5		ADDED SUPPORT WEIGHT NOTE TO CUSTOMER INSTRUCTIONS, AND -8 MUST REMAIN LEVEL TO TESTING INSTRUCTIONS, PER DAVE'S NOTES.	11/29/2022	WP	DW
6		CHANGED -1 PIVOT HOLE FROM Ø.257 TO Ø5/16 REAMED; -7 PIVOT HOLE FROM Ø.257 TO Ø5/16 REAMED; AND -12 FROM SOCKET HEAD CAP SCREW 1/4-20 X 1-1/2 TO SOCKET HEAD SHOULDER BOLT Ø5/16 X 1, APPLIED PHANTOM BOXES TO PARTS FOR CLARITY. UPDATED CUSTOMER DWGS.	6/11/2023	WP	G.E.
6A		CORRECTED DIM P/N -5d FROM 1/2-24 UNF.	7/30/2023	RJC	
7		CHD P/N -10 SETSCREW DEPTH TO .75 PER G.E.	9/28/2023	RJC	
8		CHANGED INSIDE HOLE ON -7A FROM Ø.313 TO REAM Ø.3125. ALSO CORRECTED ERROR IN BOM, -14 WAS REED #FFSC-410, NOW #FFSC-510R.	9/28/2023	WP	
8A		CHD Ø.375 REAMED TO THRU PER G.E.	8/24/2024	WP	G.E.
8B		ADDED CUSTOMER INFO TO MANUFACTURING DWGS. PER R.W.	11/2/2020	RJC	FW
8C		ADDED -19 TO SHOW MODIFICATION OF DIAL INDICATOR AND MOUNTING PER R.W.	7/12/2021	RJC	FW
8D		CHD TITLEBLOCK TOLERANCES FROM .XXX ±.005 & .XX X01 PER G.E.	2/15/2012	FJC	FW
9		MOVED ALL PARTS TO SEPARATE SHEETS. -1 ADDED Ø.25 TOOLING HOLE. -14 ADDED R.25 LEFT .30 DIA TO THEORETICAL POINT.	8/1/2013	RJC	DW
10	16-0096	UPDATED TO NEW STANDARDS. ADDED CALIBRATION NOTE. -1 CHD DIMS WAS Ø.375 THRU IS Ø.375 ±.100, WAS REAM Ø.3125 ±.03125-3192 THRU ALL (S.F. -12), WAS 1.20 ±.100, WAS (.125) ±.13. -3 CHD MATL WAS 1018 B 1018/1020 CR. CHD DIM WAS Ø.250 S.F. -13 IS Ø.250-254 THRU ALL (S.F. -13). -5A CHD DIMS WAS 3/8-24 UNF B (3/8-24 UNF-2A), WAS 3.625 ±.363, ADDED B/O #92580A109. -6 ADDED B/O #93839A815. -6A ADDED B/O #90108A417. -7 DELETED SAID TO FIT CALLOUT. -7A CHD MATL WAS 1018 B 1018/1020 CR. CHD DIMS WAS Ø.313 S.F. -14 IS Ø.3125-3165 THRU ALL (S.F. -14). WAS REAM Ø.313 ±.03125-3192 THRU ALL (S.F. -12), WAS 3.10 ±.310 ±.020-010 (S.F. -8), WAS 5.00 ±.2X .500. -8 ADDED RADIUS TO END OF SLOT. CHD DIMS WAS .188 WALL ±.19. WAS .315 SLOT ±.1. -7A IS .315 ±.010-000 (S.F. -7A). -8 CHD DIM WAS .188 WALL ±.19. -7A ADDED TO BOM. -10 ADDED B/O #91375A673. -11 REMOVED PR LOGO, ACTUAL WEIGHT, AND OPERATORS INITIALS FROM ENGRAVE NOTE. -11A ADDED TO BOM. -12A ADDED B/O #95615A120. -15 CHD DIM WAS Ø.125 ±.010 FULL R. -18 CHD DIMS WAS Ø.125 ±.010 FULL R. WAS 10-24 UNF B (10-24 UNF-25) ±.16. -17 ADDED B/O #92845A243. -18 ADDED B/O #5416A41.	8/4/2016	DPD	JAG
11	17-0089	-9A CHD LOCITE NUMBER WAS 609 ±.262. -11 CORRECTED SPELLING ON ENGRAVING WAS "CALIBRATED" & CALIBRATED. -11A CHD LOCITE NUMBER WAS 609 ±.262. -19 WAS MODIFIED B/O. DELETED DWG. -21 ADDED TO BOM QTY 1. -23 ADDED TO BOM QTY 1.	3/22/2017	DPD	JAG

ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
					-1	1	FRAME	6061		2
					-3	1	TOP BOLT TAB	1018/1020 CR		3
			X		-5	1	TOP BOLT WELDMENT			4
					-5A	1	ALL THREAD	STEEL	3/8-24 (MCMASTER-CARR #92580A109) MODIFIED	5
				B/O	-6	2	JAM NUT	STEEL	3/8-24, GRADE 5 (MCMASTER-CARR #93839A815)	1
				B/O	-6A	2	FLAT WASHER	STEEL	Ø3/8 (MCMASTER-CARR #90108A417)	1
		X			-7	1	PIVOT BAR WELDMENT			6
					-7A	1	PIVOT BAR TAB	1018/1020 CR		7
					-8	1	TUBE	CDS		8
					-9	1	EXTENSION	CDS		9
		X			-9A	2	EXTENSION ASSEMBLY			10
1	1			B/O	-10	1	SOCKET HEAD SET SCREW	STEEL	7/16-24 X 1-1/2 (MCMASTER-CARR #91375A673)	10 & 12
					-11	1	WEIGHT	BRASS		11
		X			-11A	1	WEIGHT ASSEMBLY			12
				B/O	-12	1	SOCKET HEAD SHOULDER BOLT	STEEL	1/4-20 X 7/16, Ø5/16 X 1/2 (MCMASTER-CARR #91259A383)	1
				B/O	-12A	1	NYLON LOCK NUT	STEEL	1/4-20 (MCMASTER-CARR #95615A120)	1
				B/O	-13	1	QUICK RELEASE PIN	S.S.	Ø1/4 X 1 (ESSENTIA COMPONENTS #FFSC4-10R)	1
				B/O	-14	1	QUICK RELEASE PIN	S.S.	Ø5/16 X 1 (ESSENTIA COMPONENTS #FFSC5-10R)	1
					-15	1	CLEVIS BRACKET	6061		13
					-16	1	INDICATOR BRACKET	6061		14
				B/O	-17	2	SOCKET HEAD SET SCREW (DOG POINT)	S.S.	#10-24 X 1/2 (MCMASTER-CARR #92845A243)	1
				B/O	-18	1	HOSE CLAMP	S.S.	Ø3-1/16 X Ø4 X 1/2 (MCMASTER-CARR #5416A41)	1
				B/O	-19	1	1 in. DIAL INDICATOR		(PAC-WEST #AGD-2) Δ	15
				B/O	-21	1	FLAT BACK FOR DIAL INDICATOR		FOR AGD GROUP 2 DIAL INDICATOR (MCMASTER-CARR #20625A914)	1
				B/O	-23	1	LARGE PISTOL CASE	PLASTIC	(RGR GROUP #10164)	14/5
ASSY -1A	ASSY -9A	ASSY -7	ASSY -5	B/O	DAMP ER					



NOTE:
Δ CALIBRATED UPON CUSTOMER REQUEST.

DART AEROSPACE TITLE: ROTOR DAMPER TEST DEVICE DWG NO.: RBT18520 REV 11	
MAT'L: 6061 REAT: .XXX ±.010 FRACTIONS ±18 FINISH: .XX ±.03 ANGLES ±1° SPEC: .X ±.1 SURFACES ±12° 1. BREAK ALL SHARP EDGES .015 X .65" OR .015"	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL
DRAWN BY: COLE CHECKED: MACKOVJAK OPNS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	SCALE: 1:8 DATE: 8/17/2020 SHEET 1 OF 17

